

Work Order ID 72000

Friday, July 15, 2011 10:36:52 AM



Page 1

Item ID:	D3685-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	BIPOD MOUNT ASSEMBLY					
Start Date:	7/15/2011	Start Qty:	2.00	Cust Item ID:		
Required Date:	7/22/2011	Req'd Qty:	2.00	Customer:		

Reference:

Approvals:	Process Plan:	Date:	11/07/15	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3685	Rev D

100	Pick Kit	0.00							
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Packaging	Memo	0.00				3	0		12/04/09 FF
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Packaging									
-----------	--	--	--	--	--	--	--	--	--

110	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--



Small Fab	Memo	0.00				x3	0		12-04-09 FF
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Small Fab									
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1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685

M 111791

2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685

M 119500

***Ensure holes for AN3C Bolts are free of sealant. Torque Fastners as per Dwg D3685

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 Packaging Packaging	Identify as per dwg & Stock Location: <i>ST 200</i> Memo	0.00 0.00							<i>3x</i> <i>SP</i> <i>12-07-10</i>
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/4/12</i> <i>[Signature]</i> <i>12-07-10</i>

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Picklist Print

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Work Order ID: 72000

Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY





Start Date: 7/15/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A  Bolts		Purchased	No			110	Each	40.0000	4	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351	121259			40		12			12-04-09 FF
				117514				4					
				118112				36					
D3684-047  FWD LEG ASS'Y		Manufactured	No			110	Each	0.0000	1	2			
				B 72271						2			12-04-09 FF
				B 73974						1			
D3684-049  AFT LEG ASS'Y		Manufactured	No			110	Each	2.0000	1	2			
				B 72043						2			12-04-09 FF
				B 72272						1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST078				2					
				68370				2					
D3687-3  MOUNT		Manufactured	No			110	Each	6.0000	1	2			
													12-04-09 FF
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
				61890				2					
				61964				4		3			

W/O:		WORK ORDER CHANGES					
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Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 7/15/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

D3692-1

Manufactured

No

110

Each

131.0000

8

16



SPACER



(3)

12-04-09
FF

Location

Loc Qty

Loc Code

ST075

78607

131

51467

73232

131

110

Each

872.0000

4

8

MS21043-3

Purchased

No



(3)

12-04-09
FF

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

800

112314

65

118077

735

118614

12

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

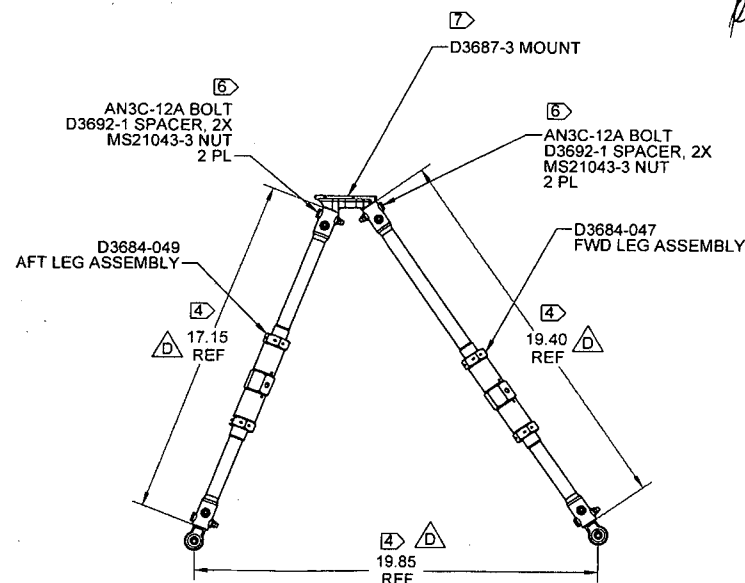
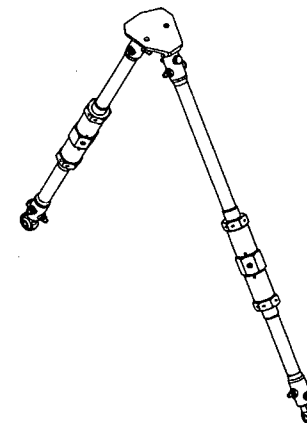
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72060
111-0715



D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
2010-03-15
NP

D	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3685	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BIPOD MOUNT ASSEMBLY	NTS
DATE	10.03.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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